Work Order ID 74513 Monday, October 03, 2011 2:38:00 PM	•								Page	1
Item ID: D3535-39 Revision ID:		Accept				se se	etup S	[[BE111]		
Item Name: Wearshoe Start Date: 9/30/2011 Start Qty Required Date: 10/14/2011 Req'd Qty Reference:			Cust Item II Customer:	D:			3	.top 		
Approvals: Process Plan: M.C.	Date: 1 1 10	U3Tooling: SPC (Y/N):		ite:		R		tart		
Sequence ID/ Operation Work Center ID Description		Set Up/ Run Hours	Tool ID	Tool# I	Plan Code	Accept Qty	Reject Qty	Reject Numbe		
Draw Nbr Revision Nbr D3535 Rev B										 ;
100 . FLOW WAT	Memo 1-Cut as per Dwg D3535 DDwg! Deburr if necessary	0.00° Rev: \$\int_{0.00}^{0.00} \prog \text{Rev:}_{}\$	\$_ □2-				<u> </u>	-27		-
	et parts off machine FAI/FAIB Memo	0.00				<u> </u>	<u>- 10- ;</u>	רלכ		_
	et parts - second check Memo	0.00 کر ار ء	0/25			(42)				

Dart Aerospac	e Ltd
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W/O:		W	WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						

Part No:	PAR #: Fault Category: _	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC	Verification	Annroyal	Approval								
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector					
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		•	-				:						

Work Order ID 74513

Required Date: 10/14/2011

Monday, October 03, 2011 2:38:00 PM



Page 2

Item ID:

D3535-39

Accept



Setup Start

Stop



Revision ID:

Item Name: Start Date:

Wearshoe

9/30/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N): Date:

Date:

Start Run



Sequence ID/

Work Center ID

Operation Description Set Up/ **Run Hours**

Tool # Plan Code

Accept Oty

Reject Qty

Stop

Reject Insp. Number Stamp

130

Brake NC

Brake NC

NC BRAKE

Memo

Memo

0.00

0.00

Deburr if necessary ☐ Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. ☐ Identify as D3535-41 ☐ Form Joggle on brake using Jig DT8158 as per Dwg D3535

Dwg D3535

140

Quality Control

OC5- Inspect part completeness to step on W/O

0.00

0.00

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per Q\$1005 4.3

0.00

W/18434

START TIME: S

OFINISH TIME:

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W/O:		·	WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		esolution:								•
NCR:			WORK ORDE	R NON-CONFORMA	NCE (N	CR)	,			
DATE	STEP	Description of NC	Initial	Corrective Action Section		0	Verific		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	D	ın & ate	Section	on C	Chief Eng	QC Inspector
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Work Order ID 74513

Monday, October 03, 2011 2:38:00 PM



Page 3

Item ID:

D3535-39

Accept



Setup Start



Revision ID:

Item Name:

Wearshoe

Start Date:

9/30/2011 **Required Date: 10/14/2011** Start Qty: 12.00

Req'd Qty: 12.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Stop

Stop



Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Oty

Run

Reject Number Stamp

Insp.

170

Packaging

Packaging

Identify as per dwg & Stock Location: FY

0.00

Memo

0.00

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			WORK ORDER CHANGES											
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NCR:			NORK ORI	DER NON-CONFO	RMANCE	(NCR)								
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip Chief Eng	Section B otion	Sign & Date	Verifica Section		Approval Chief Eng	Approval QC inspector				
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Picklist Print

Monday, October 03, 2011 2:38:06 PM

Work Order ID: 74513

Parent Item:

D3535-39

Parent Item Name: Wearshoe



Start Date: 9/30/2011

Required Date: 10/14/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM

Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	•	_ast _ocation	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA	I (Purchased	No			100	sf	170.5795	0.951	12.01263		-	
304/316 .040 Sheet										HB(()	-10-9	ገ	
				Location		Loc C	<u>Oty</u>	Loc Code					
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	R	esolution:	Disposit	ion:	QA: N	VC Clos	sed:		Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	ANCE (NCR)				
DATE	STEP	Description of NC	Initial		ion B	Sign &		ation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	•	Date	Secti	on C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	74513
Description: Wearshoe	Part Number:	D3535-39
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815		-	T 1801	
32.775	+/-0.010	37,774	4		7	
29.275	+/-0.010	29774			7	
25.775	+/-0.010	25,778	4		7	
23.250	+/-0.010	23,850	<u>ا</u>		T	
19.750	+/-0.010	19.750	4		T	
17.750	+/-0.010	17.706	<u></u>		T	
14.250	+/-0.010	14.256	D		Т	
9.500	+/-0.010	9,500	20		T	
4.750	+/-0.010	4,750	*		T	
2.000	+/-0.010	7001	8		V 1302	
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Ø0.188	+0.005/-0.001	491.	L		V	
1.885	+/-0.010	1.885	>	-	V	
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0.300	+/-0.010	.306	*		V	
0.038	+/-0.010	,037	*		V	
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Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-10-57	Date: ullo128	Date:	N/A

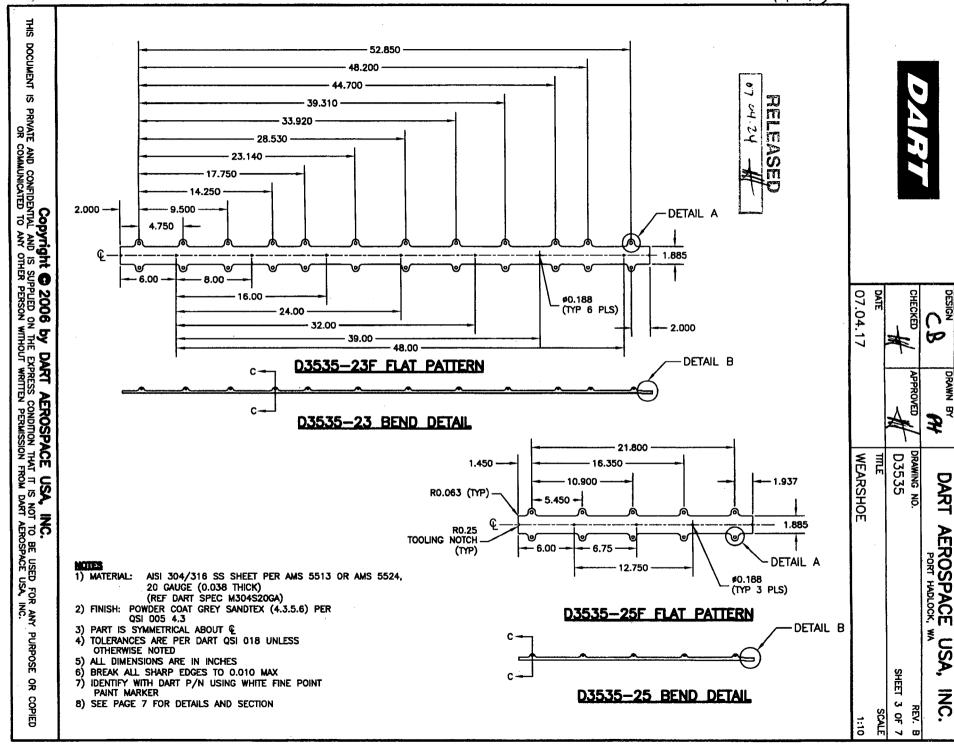
Rev	Date	Change	Revised by	Approved
Α	07.07.18	New Issue	KJ/JLM ox	E

W/O:			WC	RK ORDER (CHANGES				
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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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CHECKED 11	APPROVED i//	DRAWING NO.
	4	D3535
DATE		TITLE
07.04.17		WEARSHOE

SHEET

SCALE OF 7

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REV. B

ZC.

22.500 19.000 6.000 2.000 1.885 6.00 DETAIL A ≠0.188 (TYP 3 PLS) D3535-31F FLAT PATTERN



24.500
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D3535-33F FLAT PATTERN

D3535-33 BEND DETAIL

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SA, INC.
IS NOT TO BE USED FOR ANY
A DART AEROSPACE USA, INC.

PURPOSE

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1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,

20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT Q.
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES TO 0.010 MAX
7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:			M	ORK ORDER CHAN	GES					
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RELEASE

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5 OF 7 REV. B

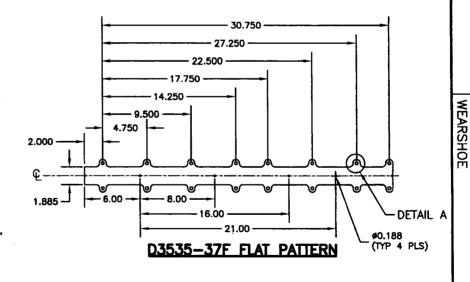
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07.04.17

- 23.250 19.750 17.750 14.250 9.500 4.750 2.000 **#0.188** 1.885 (TYP 2 PLS) -DETAIL A D3535-35F FLAT PATTERN





D3535-37 BEND DETAIL

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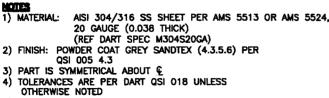
1) MATERIAL:

ALL DIMENSIONS ARE IN INCHES

BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER





8) SEE PAGE 7 FOR DETAILS AND SECTION

Dart Aerosp	ace	Ltd
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W/O:			W	ORK ORDER CHANG	GES			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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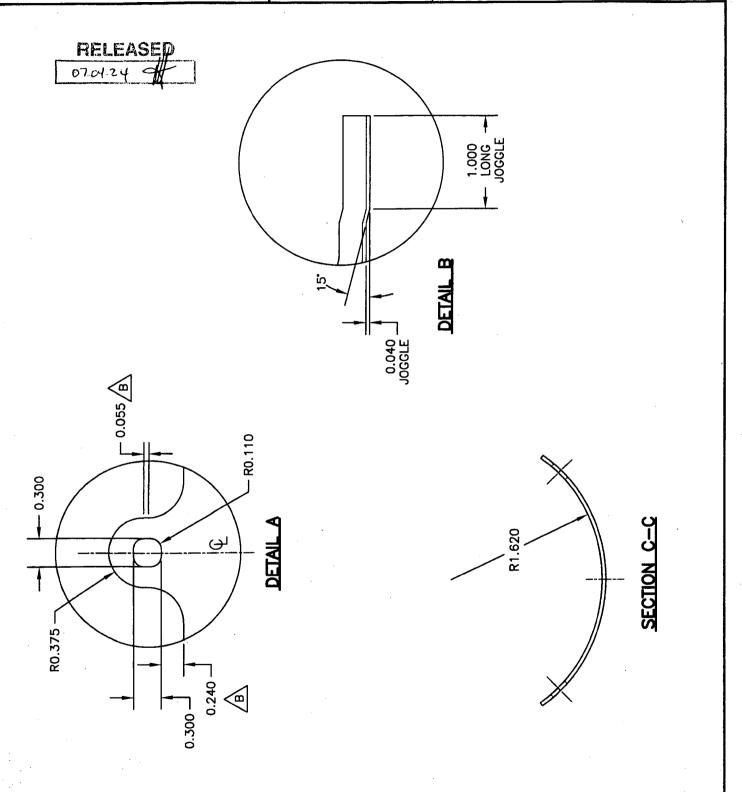
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Dart Aerospace Ltd

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4		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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